

Work Order ID 156032

Tuesday, January 24, 2017 8:11:10 AM

156032

Page 1

Item ID: D2574

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Aft, In

Start Date: 1/24/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 2/10/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2574

F

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.02

0.49

Memo

Program Batch No. **B156032**Double check by: **gmk**

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

DAS
08
9-89**8****8**DAS
14
9-89**17/01/31**

110

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

0.04

Memo

Machine keyway as per dwg D2573 & D2574

DAS
08
9-89**8****8**DAS
14
9-89**17/01/31**

156032

Tuesday, January 24, 2017 8:11:10 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 1/24/2017 **Start Qty:** 8.00 ***g***

Required Date: 2/10/2017 **Req'd Qty:** 8.00 ***Q***

Customer:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

D.A. 17-61-29

120

0.01

QC

Memo

Quality Control

0.00

130

OC

Memo

Quality Control

0.00

140

HandFinish

Memo

Hand Finishing

0.04

18 ~~0~~ 2017/02/08
BET.

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Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, In
Start Date: 1/24/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 2/10/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>M 1361B</i> Memo START TIME: <i>2:25</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>2:55</i>	0.00 0.03				<i>8</i>	<i>0</i>	<i>17-028</i>	<i>2 3 8</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<i>8</i>			DAS 38 9-89 FEB 08 2017
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>5498</i> Memo	0.00 0.01				<i>8</i>			DAS 6 9-89 FEB 24 2017

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Item ID: D2574 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft, In
Start Date: 1/24/2017 Start Qty: 8.00 ***g*** Cust Item ID:
Required Date: 2/10/2017 Req'd Qty: 8.00 ***g*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180							DAS 21	FEB 24 2017	
QC	Memo	0.13					9-89		
Quality Control									

DAS
21
9-89
FEB 24 2017

Picklist Print

Tuesday, January 24, 2017 8:11:09 AM

Page 1

Work Order ID: 156032

156032

Parent Item: D2574

D2574

Parent Item Name: Saddle, Aft, In

Start Date: 1/24/2017

Required Date: 2/10/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			110	Each	36.0000	1	8			

D6101-005

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

16

152208

16

MAT041

20

153935

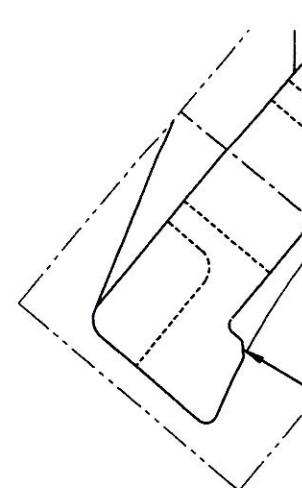
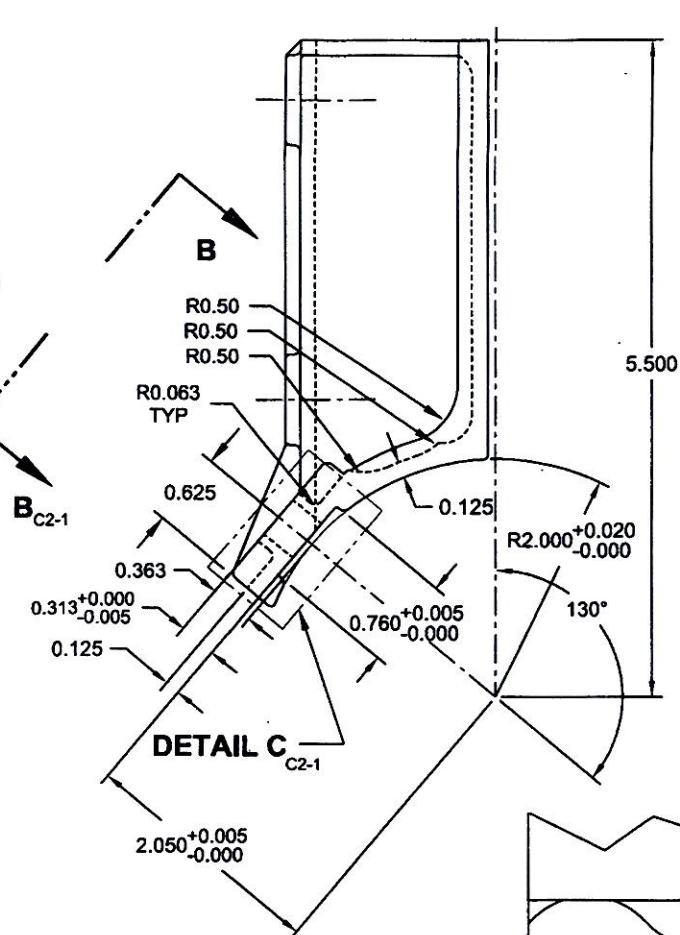
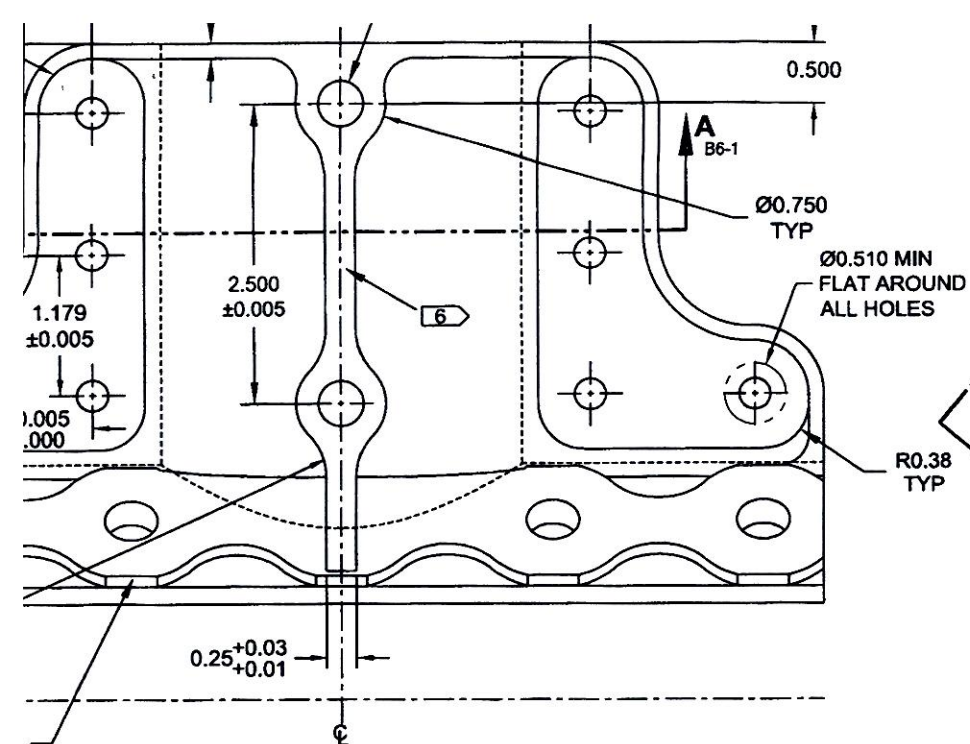
20

DAS

45 17-01-27

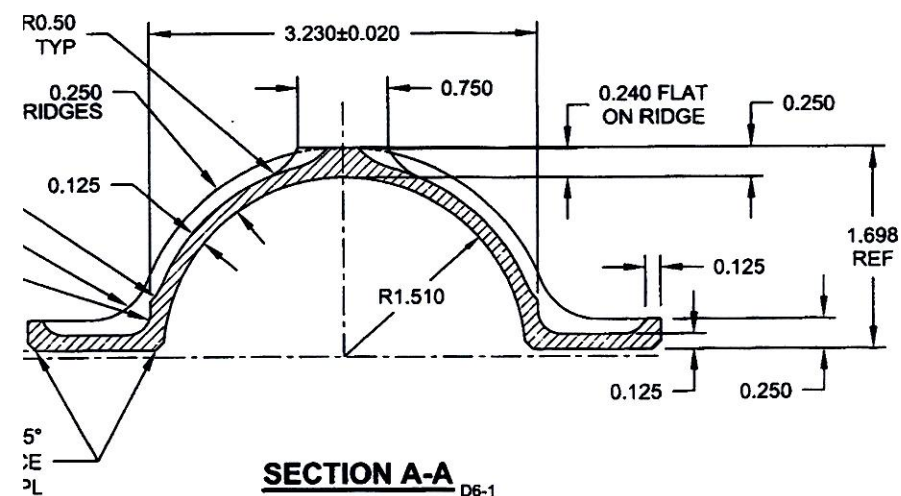
9-89

8

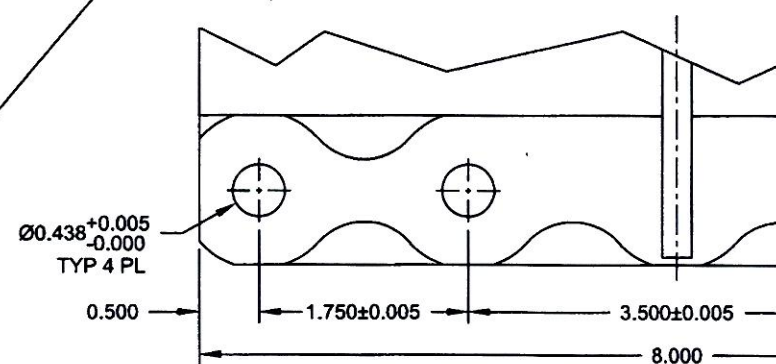


DETAIL C
SCALE: 2x

VIEW B-B



SECTION A-A
D6-1



D2574 INNER AFT SADDLE

F	D6101-005 WAS D6102-003 REF NC	
E	ADD CHAMFER ON RIDGE, NOTE 4	
D	ADD RIDGES; TIGHTEN TOLERANC	
C	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	ADD GRAIN DIR., 0.438 WAS 0.425	
A	NEW ISSUE	
REV.	DESCRIPTION	
DESIGN	DS	DAF HAW DRAWING NC
DRAWN	SFM	
CHECKED		

-A-250/12 (REF DART SPEC. D6101-005)
 ER DART QSI 005 4.1
 REF 4.3.5.1) PER DART QSI 005 4.3
 18 UNLESS OTHERWISE NOTED

DART AEROSPACE LTD	Work Order: 15037
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.998	7.998		
F	0.490	0.510		0.498	0.496	0.499	0.497		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.500	0.501	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.566	0.568	0.568	0.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.253	0.252	0.252	0.251		
S	0.115	0.135		0.123	0.123	0.123	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.238	0.240	0.240	0.240		
W	0.115	0.135		0.118	0.118	0.118	0.118		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.364	0.363	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.250	0.250	0.250		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.244	0.246	0.244		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

DAS

44

9-55

Measured by: A. a. DAS
Date: 17-01-29 CB

Audited by: 9-55
Date: 17-02-02

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 156032
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	37	48		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.998	7.998		
F	0.490	0.510		0.500	0.501	.500	.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.125	0.126	.126	.126		
R	0.240	0.260		0.252	0.252	.253	.253		
S	0.115	0.135		0.122	0.123	.124	.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	0.239	.238	.239		
W	0.115	0.135		0.118	0.118	.118	.118		
X	0.307	0.312		0.311	0.311	.312	.312		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.363	0.364	.364	.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.624	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250	.247	.249		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.244	.244	.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject				DAS	DAS	DAS	DAS		

Measured by: D.F.	DAS 14
Date: 17-01-30	08 9-89
	17/01/31

Audited by: 44	DAS
Date: 17-02-02	9-89

Rev	Date	Change	Revised by	Approved
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	